

Date: Monday, 25/05/2009 12:49:59 PM  
 User: Julie Dawson

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: RIB		
Job Number	: 48201		Part Number	: D22217		
Estimate Number	: 13675		Drawing Number	: D2221 REV H (PG.5)		
P.O. Number	:		Project Number	: N/A		
This Issue	: 25/05/2009	S.O. No. :	Drawing Revision	: H		
Prsht Rev.	: NC		Material	:		
First Issue	: / /	Type	: LARGE FAB ASSY			
Previous Run	: 46769		Due Date	: 29/05/2009		Qty: 4 Um: Each
Written By	:					
Checked & Approved By	: <u>Jul 09.05.25</u>					
Comment	: Est Rev:A New Issue 08-12-02 DD verified by:EC					
Additional Product						
Job Number: 						
Seq. #:	Machine Or Operation:	Description :				
1.0	M304TS0750W065	304 SQ Tube .75x.75x.065W 				
Comment: Qty.: 4.8344 f(s)/Unit Total : 19.3376 f(s) 304 SQ Tube .75x.75x.065W batch: <u>2007111432</u> <u>SAD 09-05-26</u>						
2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1 				
Comment: LARGE FABRICATION RESOURCE 1  1- Cut as per dwg D2221 2- Deburr and remove identification markings on tube <u>SAD 09-05-26</u>						
3.0	QC5	INSPECT WORK TO CURRENT STEP 				
Comment: INSPECT WORK TO CURRENT STEP <u>8071566 (X)</u>						
4.0	PACKAGING 1	PACKAGING RESOURCE #1 				
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <u>Disket 1</u> <u>PD 09.05.26 (1)</u>						
5.0	QC21	FINAL INSPECTION/W/O RELEASE 				
Comment: FINAL INSPECTION/W/O RELEASE <u>09/05/27 (1)</u>						
Job Completion 						

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

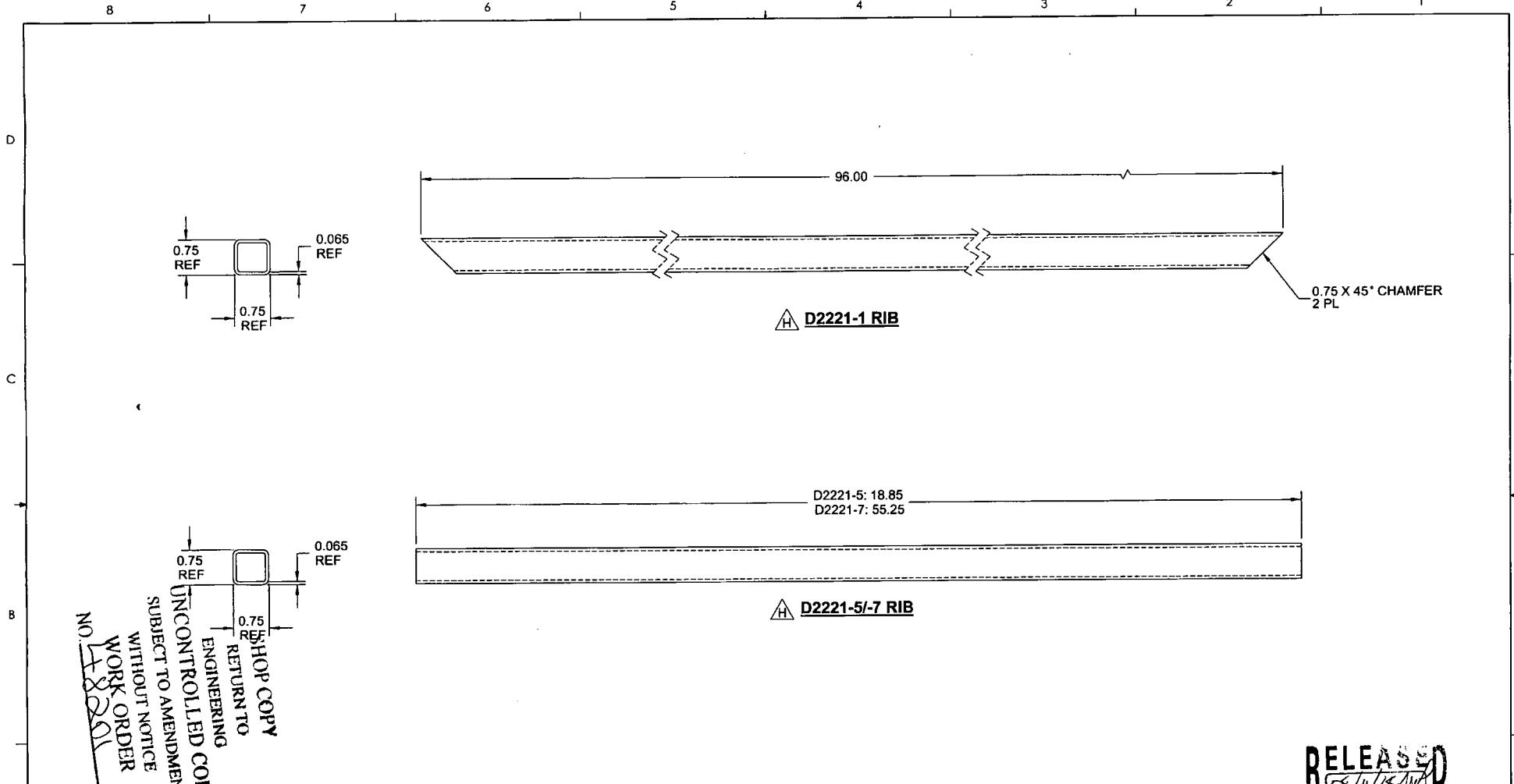
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



NOTES:  
 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL  
 REF. DART SPEC. M304TS0.750W0.065  
 2) FINISH: NONE  
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 4) UNITS: INCHES UNLESS OTHERWISE NOTED  
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
 6) IDENTIFICATION: N/A  
 8) WEIGHT:D2221 -1 = 4.57 lbs; D2221-5 = 0.90 lbs; D2221-7 2.65 = lbs

DESIGN	BW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		REV. H	
MFG. APPR.		D2221	
APPROVED		SHEET 5 OF 5	
DE APPR.		TITLE	
DATE	08.09.18	SCALE	
		BASKET BASE ASSEMBLY (350) NTS	
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RELEASED  
08/11/16 JV

8 7 6 5 4 3 2 1